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5 Claim 14 (amended twice). A method for making a print cartridge structure containing an ink reservoir body for a multi-color thermal ink jet printer which comprises casting or molding a multi-function substrate carrier from a material selected from the group consisting of carbon fibers, graphite, metal-ceramic materials and metals, the substrate carrier having a top surface having a perimeter and containing one or more substrate locator wells each well having well walls, a well base and at least one ink feed slot in each well base, the carrier including one or more chambers on an opposing side of the substrate carrier from the locator wells, each chamber being in flow communication with a corresponding substrate locator well, side walls attached to the top surface along

10 the perimeter thereof wherein one or more of the side walls contain fins for heat removal from the substrate carrier and at least two alignment devices adjacent one of the side walls for precisely attaching the substrate carrier and reservoir body to a printer carriage, providing an ink reservoir body and attaching the ink reservoir body to the substrate carrier.

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5 Claim 25 (amended twice). A nose piece for an ink jet printer cartridge, the nose piece comprising a machined, molded or cast, substantially metal structure having a top surface having a perimeter and containing one or more substrate locator wells each well having well walls, a well base and at least one ink feed slot in each well base, the nose piece including one or more chambers on an opposing side of the nose piece from the locator wells, each chamber being in flow communication with a corresponding locator well, side walls attached to the top surface along the perimeter thereof wherein one or more of the side walls contain fins for heat removal from the [substrate carrier] nose piece, a plurality of slots along the perimeter of the side walls for precisely attaching

10 the nose piece to an ink reservoir body and at least two alignment devices adjacent one of the side walls for precisely aligning the nose piece and reservoir body to a printer